

Work Order ID 53968

November 24, 2009 11:16:33 AM



Page 1

Item ID:	D2873-045	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Nut Plate Assembly					
Start Date:	25/11/2009	Start Qty: 20.00		Cust Item ID:		
Required Date:	07/12/2009	Req'd Qty: 20.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date: 09/11/24	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2873	Rev A								
100	BAND SAW	0.00							
	Bandsaw								
Jeaspa Bandsaw	Memo Cut blanks: 1.000" x 0.375" x 2.700" long	0.00					20	5	
110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
HAAS CNC vertical machine #1	Memo Machine as per Folio FA and Dwg D2873 Identify as D2873-5 Dwg Rev A F1819 Folio Rev A	0.00					20		
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00					20		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00	88	09/11/28		20			
140 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Deburr □2- C'sink as per Dwg D2873								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00	27	502/11/30		counter 420	φ		

88 09/11/28 20

counter
420

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Setup Start



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Start Date: 25/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 07/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	09/12/01			420	9		
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	09-12-1			10			
180 Small Fab Small Fab Small Fab	Small Fab Memo 1-Assemble as per Dwg D2873 <input type="checkbox"/> 2-Identify as D2873-045	0.00 0.00							20

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

⇒ 807/12/01

Quality Control

counts
(120)

f

200

Identify as per dwg & Stock Location: X-tubes

0.00



Packaging

Memo

0.00

Finishing

Packaging

m

09

12

02

(20)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/03

mf 0912-02

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Picklist Print

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Page 1

Work Order ID: 53968

Parent Item: D2873-045RevA

Parent Item Name: Nut Plate Assembly

Comments:

Start Date: 25/11/2009

Required Date: 07/12/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21075L5

Purchased

No

100

Each

410.0000

40.0000



Nut Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

410

110916

79

112243

331

M6061T6B0.375X01.00
0

Purchased

No

180

f

17.6095

4.7368



6061T6 BAR .375 x 1.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

17.60947368

105225

5.3

→ 110829

12.3094737

9/09/12/01

40

4.7368 mf 09/11/27

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Required Date: 07/12/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD4-6  Rivet		Purchased	No			180	Each	3,930.000	80.0000			

Eff 09/12/01

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3930	
100151	27	
103395	14	
105144	88	
110139	3774	
2525	27	

~~70~~ 77
3

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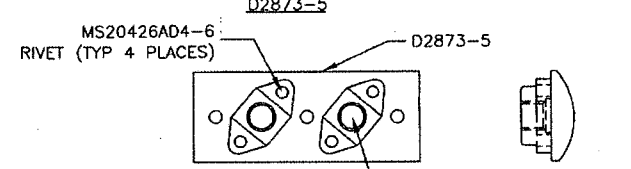
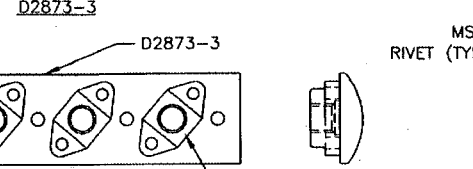
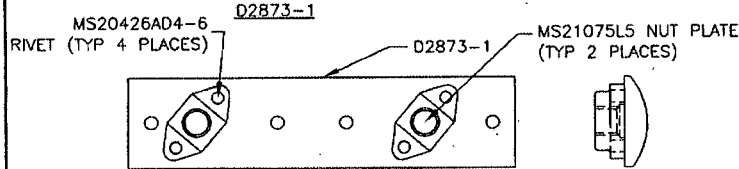
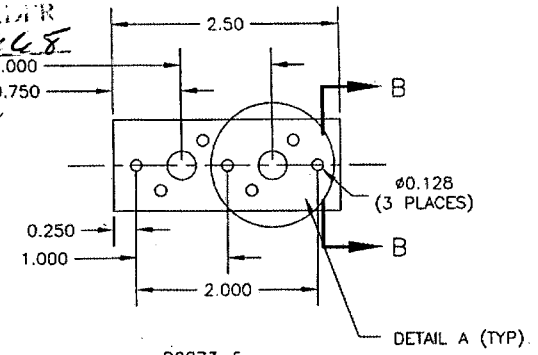
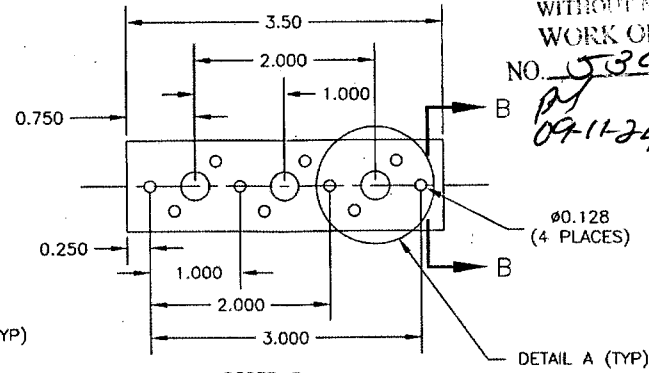
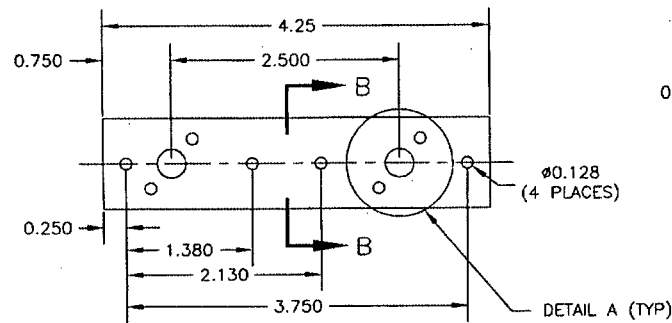
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO APPROVAL

WITHOUT NOTICE
WORK ORDER

NO. 53968
09-11-24



D2873-041

MS20426AD4-6
RIVET (TYP 6 PLACES)

D2873-043

MS21075L5 NUT PLATE
(TYP 3 PLACES)

D2873-045

MS21075L5 NUT PLATE
(TYP 2 PLACES)

D2873-1/-3/-5 RADIUS BLOCK

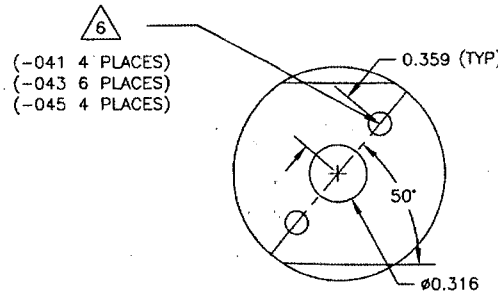
- MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE INCHES
- BREAK ALL SHARP EDGES 0.010 TO 0.020
- Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

D2873-041/-043/-045 NUT PLATE ASSEMBLY

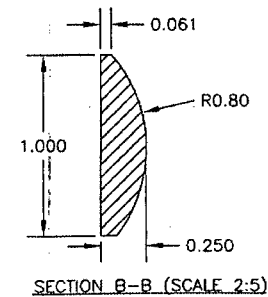
- INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



DETAIL A (SCALE 2:5)



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN	PH	PH
CHECKED	DS	DS
DATE	05.07.26	TITLE
		RADIUS BLOCK
		SCALE
		4:5